

Date: Wednesday, 7/11/2007 2:49:12 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STRUT WELDMENT ASS'Y
Job Number : 33492	
Estimate Number : 10678	
P.O. Number : N/A	Part Number : D3443043
This Issue : 7/11/2007 S.O. No. : N/A	Drawing Number : D3443 REVB
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : B
Previous Run : 29672	Material : N/A
Written By : _____	Due Date : 7/30/2007 Qty: 4 Um: Each
Checked & Approved By : <u>[Signature]</u>	
Comment : EST. REV. A 05.11.17 NEW ISSUE EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D34437	Tubing
-----	--------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3443-7	TUBING	B29676 → 2 B33505 → 2

PD 07-07-23 (4)

2.0	D34433	Clevis
-----	--------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3443-3	CLEVIS	B30159

PD 07-07-23 (4)

3.0	238805	SS DOWEL PIN 3/4" LONG
-----	--------	------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	238-805	SS DOWEL PIN 3/4" LONG	M105037 → 1 M19080 → 3

PD 07-07-23 (4)

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

Weld assembly as per dwg D3443

PD 07-07-23 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ED Date: 07/07/25  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 7/11/2007 2:49:12 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT WELDMENT ASS'Y

Job Number: 33492

Part Number: D3443043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/07/23

(4)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/07/23

(4)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1-Mask holes as per dwg D3443

2-Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

BK

07-07-24

(4)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MF

07-07-25

(4)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

MF

07-07-25

(4)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/07/25

(4)

Job Completion



12 20x25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

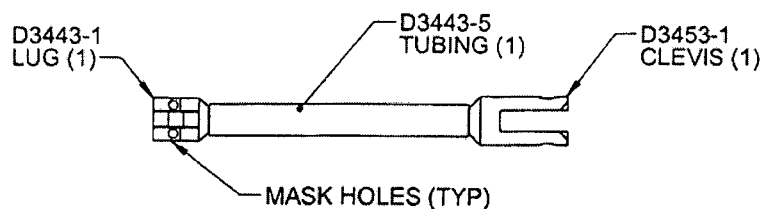
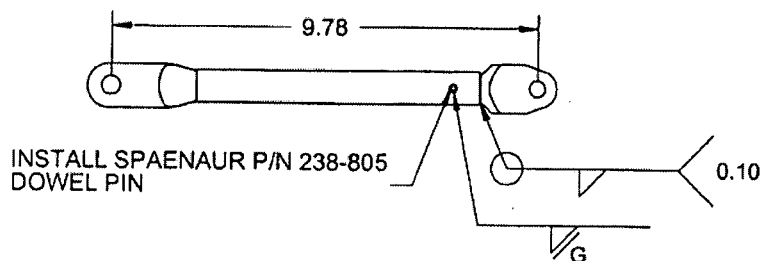
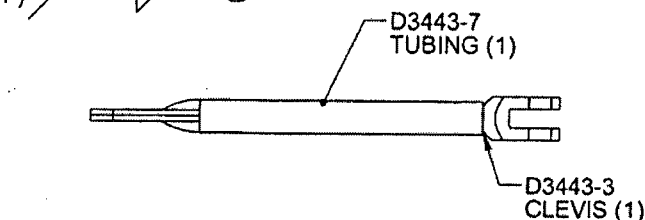
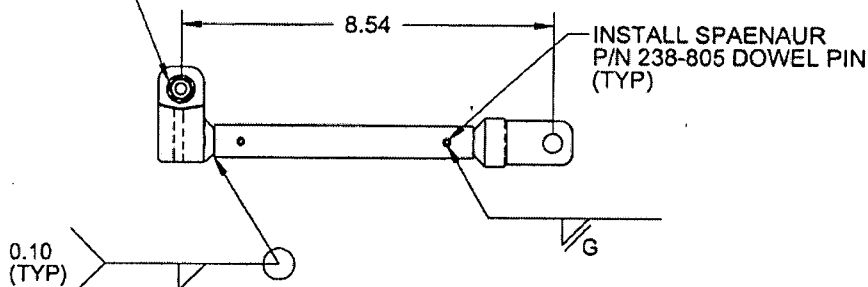
NOTE: Date & initial all entries

**DART**

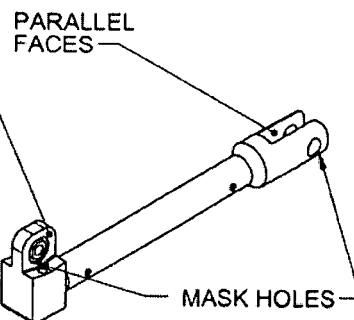
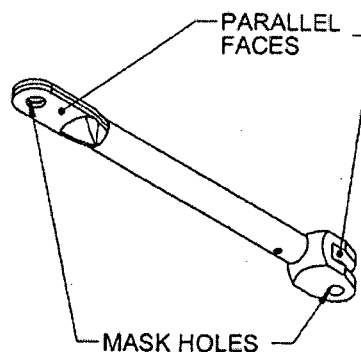
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CHECKED #	APPROVED #	DRAWING NO. <b>D3443</b>	REV. B SHEET 1 OF 3
DATE <b>05.12.05</b>		TITLE <b>STRUT WELDMENT ASSEMBLY</b>	SCALE 1:4
A	05.09.02	NEW ISSUE	
B	05.12.05	ADDED -9 PIN; REMOVED BALL PLUNGER; REVISE TOLERANCE; & Ø0.125 WAS #30	

**RELEASED**

05.12.09 #

PRESS FIT McMASTER-CARR P/N 63215K32  
BALL JOINT BEARING AFTER POWDER COAT**NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

**D3443-041****D3443-043**SHOP COPY  
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WITHOUT NOTICE

WORK ORDER

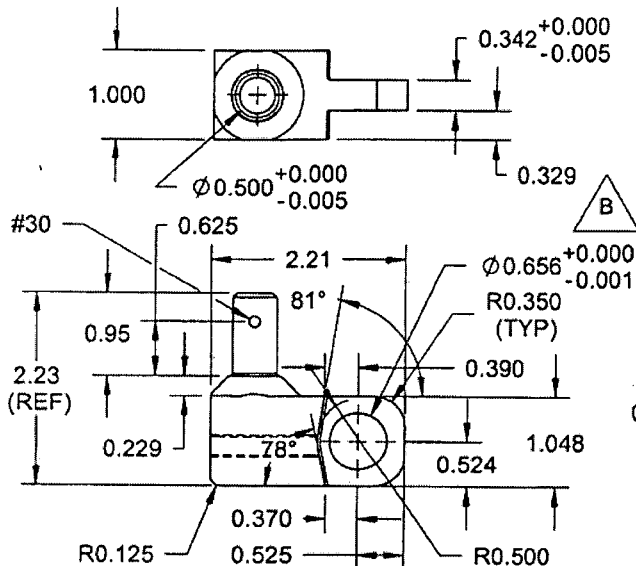
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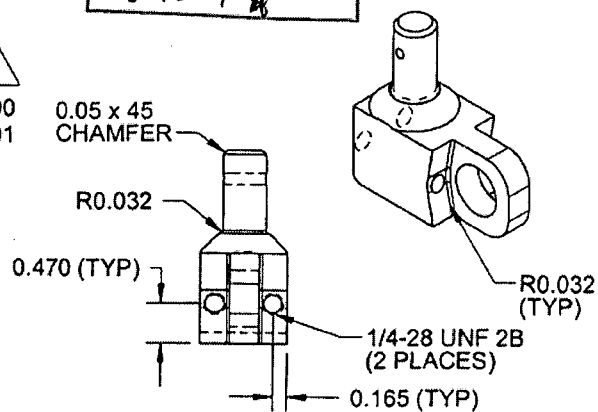
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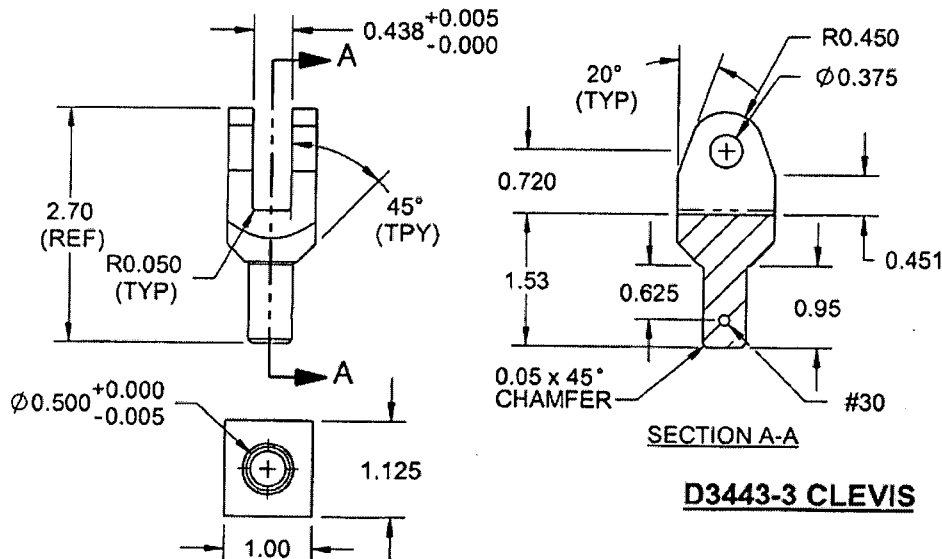
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CHECKED #	APPROVED #	DRAWING NO. <b>D3443</b>	REV. B SHEET 2 OF 3
DATE <b>05.12.05</b>	TITLE <b>STRUT WELDMENT ASSEMBLY 1:2</b>		

**RELEASED**

05.12.04 #

**D3443-1 LUG****D3443-1 NOTES:**

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC M17-4B)

**D3443-3 CLEVIS****D3443-3 NOTES:**

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)

**GENERAL NOTES:**

- 2) FINISH: NONE  
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) ALL DIMENSIONS ARE IN INCHES  
5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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NO. 33492

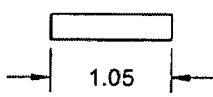
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3443</b>	REV. B SHEET 3 OF 3
DATE <b>05.12.05</b>		TITLE <b>STRUT WELDMENT ASSEMBLY</b>	SCALE <b>1:2</b>

$\varnothing 0.210^{+0.005}_{-0.010}$



**D3443-9 PIN**

**D3443-9 NOTES:**

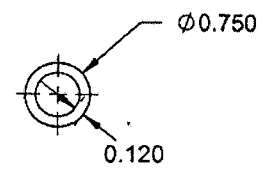
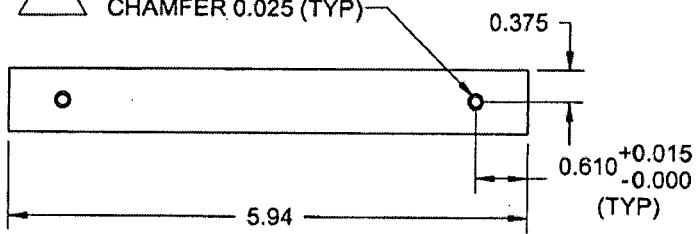
- 1) MATERIAL: DELRIN II 150R OR ACETRON GP ACETAIL (REF. DART SPEC M-DELRIN-R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

**RELEASED**

05.12.09 *[Signature]*

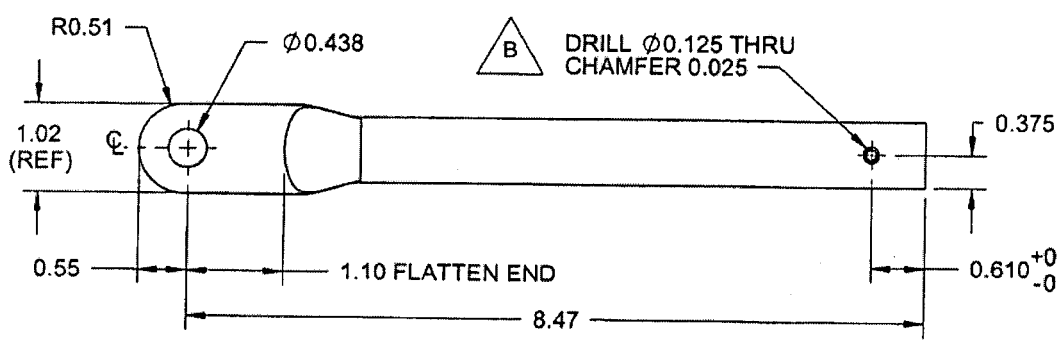
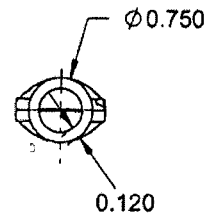
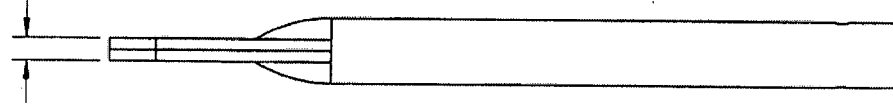


DRILL  $\varnothing 0.125$  THRU  
CHAMFER 0.025 (TYP)



**D3443-5 TUBING**

$0.260^{+0.000}_{-0.030}$



**D3443-7 TUBING**

**D3443-5/-7 NOTES:**

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC M304TR0.7500WT120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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